

Work Order ID 52260

September 22, 2009 7:31:11 AM



Page 1

Item ID: D412-694-011

Accept



Setup Start



Revision ID: N/A

Item Name: Spacedoors

Stop



Start Date: 9/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *CL*

Date: 09/09/22 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100



DC

Document Control

DOCUMENT CONTROL

X

0.00

Memo

0.00

Photocopy bluefile and create labels per PPP D412-694-011 CHG005

8/10/07

Handwritten: BG 11-9-30

110



Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: *10435* D3119-041 Cover
Assembly: D3119-042 Cover Assembly: D3140-05/-07 Door
(for D412-694-01/-03) (D3140-06/-08 Door (for D412-694-02/-
04) Supplier: Delastek Ship to Delastek Qty

Handwritten: CL 09/09/22 (1)

120



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure material certification is attached

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52260

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Item ID: D412-694-011

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Revision ID: N/A

Item Name: Spacedoors

Stop



Start Date: 9/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Visual inspection. Check for void spot and pins. Check over all dimensions and windows as per Dwg D3140. Bring to composite room for assembly

8 (For J.M)

u110/26

140



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

11/9/308

150



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

8 u110/26

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 52260

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Item ID: D412-694-011

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Setup Start



Revision ID: N/A

Item Name: Spacedoors

Stop



Start Date: 9/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-694-011 Location: 119 PPP Rev: F

11/10/23

170

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/10/31
me
11-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 7:31:11 AM

Page 1

Work Order ID: 52260

Parent Item: D412-694-011RevN/A

Parent Item Name: Spacedoors

Comments:








Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D412-694-01RevC1  Door Assembly		Manufactured	No			110	Each	0.0000	1.0000			
D412-694-02RevC1  Door Assembly		Manufactured	No			110	Each	0.0000	1.0000			
D412-694-03RevC1  Door Assembly		Manufactured	No			110	Each	0.0000	1.0000			
DSI 9363-011RevA  Shim		Manufactured	No			110	Each	0.0000	1.0000			
BSP45  Commercial Rivet		Purchased	No			150	Each	270.0000	48.0000			

B52626

B52261

B52627

B66258

M112930

M118614

11/13/09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

270

107296

270

11821

0

D3140-5-7 B 52628 double kit
already pulled on

Pto →

W/O: <u>52260</u>		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-694-04 PAR #: N/A Fault Category: Production Control NCR: Yes No DQA: 11/11/10 Date: 11/11/10
 Resolution: Re work Disposition: Re work QA: N/C Closed: 11/11/10 Date: 11/11/10

NCR: <u>11/11/10</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/10/04</u>	<u>#100</u>	Missing D412-694-04 From wlo. Part is on ITN. R.C. wlo is incorrect	<u>P</u> <u>11/10/31</u> <u>05/04/12</u>	ADD to kit D412-694-04 B <u>52262</u>	<u>ulok</u> <u>sl</u>	<u>ulok</u>	<u>P</u> <u>11/10/31</u> <u>05/04/12</u>	<u>ulok</u> <u>11/10/04</u>
		<u>LOA</u>	<u>P</u> <u>11/10/31</u>	ADD to wlo + Bom. Attach Bom to wlo for red that change was Done.	<u>11/10/31</u>	<u>ulok</u>	<u>P</u> <u>11/10/31</u>	<u>ulok</u> <u>11/10/04</u>
				(Was There)				

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 7:31:11 AM

Work Order ID: 52260

Parent Item: D412-694-011RevN/A

Parent Item Name: Spacedoors



Comments:

Start Date: 9/22/09

Required Date: 11/13/09



Start Qty: 1.00

Required Qty: 1.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2126RevC  Seal		Manufactured	No			150	f	497.2000	12.1666 	3680188		

5 cut 73.0"
x2 per kit

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	497.2	
42154	51.7	
48285	445.5	

D3090-1RevB  Shim 0.250		Manufactured	No			150	Each	31.0000	4.0000 			
--	--	--------------	----	--	--	-----	------	---------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	31	
18037	31	

D3090-3RevB  Shim 0.125		Manufactured	No			150	Each	31.0000	4.0000 			
--	--	--------------	----	--	--	-----	------	---------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	31	
18040	31	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 7:31:11 AM

Work Order ID: 52260

Parent Item: D412-694-011RevN/A

Parent Item Name: Spacedoors



Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3108-1RevB1		Manufactured	No			150	Each	5.0000	2.0000			
												
Decal												

①
B55562 *[Signature]*

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	5	
18625	1	
31890	4	



[Handwritten marks]

D3108-2RevB1		Manufactured	No			150	Each	5.0000	2.0000			
												
Decal												

B55563 *[Signature]*

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	5	
31891	5	

[Handwritten marks]

D3108-3RevB1		Manufactured	No			150	Each	24.0000	4.0000			
												
Decal												

11/9/09 *[Signature]*

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	24	
17030	1	
18628	2	
31892	1	
50374	20	

[Handwritten marks]

September 22, 2009 7:31:11 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 7:31:11 AM

Work Order ID: 52260

Parent Item: D412-694-011RevN/A

Parent Item Name: Spacedoors



Comments:

Start Date: 9/22/09

Required Date: 11/13/09



Start Qty: 1.00

Required Qty: 1.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3108-5RevB1		Manufactured	No			150	Each	5.0000	4.0000			
												
Decal												

B555668

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	5	
31893	1	
50350	4	

D3108-7RevB1		Manufactured	No			150	Each	18.0000	2.0000			
												
Decal												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	18	
36723	18	

D3116-1RevA		Manufactured	No			150	f	99.0400	8.3333			
												
Seal												

2
11/19/308

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	99.04	
17295	15.83	
24697	83.21	

cut to 50.6"
x205 kit → 7/19/09
8/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 7:31:11 AM

Work Order ID: 52260

Parent Item: D412-694-011RevN/A

Parent Item Name: Spacedoors

Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3116-3RevA -0500		Manufactured	No			150	f	83.7000	8.3333			



Seal

cut @ 50.0"
2 per kit -> meas
Ducor/30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

83.7

17296

8.67

27240

75.03

150

f

534.5000

8.6666

D3116-9RevA -0730



Seal

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

534.5

17463

6.5

39182

528

cut @ 77.0"

(X) per kit -> Ducor/30
meas

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 7:31:11 AM

Work Order ID: 52260

Parent Item: D412-694-011RevN/A

Parent Item Name: Spacedoors

Comments:



Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3118-3RevC		Manufactured	No			150	Each	18.0000	4.0000	3		
Sign Assembly												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

43242

1

45265

12

Main Warehouse

ST65

5

50365

5

D3118-5RevC

Manufactured

No

150

Each

0.0000

4.0000

Sign Assembly

D3128-1RevB

Manufactured

No

150

Each

13.0000

4.0000

Shim

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

1053617

5

18643

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 7:31:11 AM

Work Order ID: 52260

Parent Item: D412-694-011RevN/A

Parent Item Name: Spacedoors




Comments:

Start Date: 9/22/09



Required Date: 11/13/09

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S D3144-15RevC  Doubler		Manufactured	No			150	Each	11.0000	2.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	11	
24724	2	
35338	9	


S D3300-1RevA  Window		Manufactured	No			150	Each	3.0000	2.0000 			
--	--	--------------	----	--	--	-----	------	--------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
50313	3	

S D412-694-015RevN/A  Replacement Window	CH67002	Manufactured	No			150	Each	11.0000	4.0000 			
---	---------	--------------	----	--	--	-----	------	---------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG	11	
31204	1	
47519	6	
50259	4	

B5608 

B59823 ^③
11/9/20  53753 ^①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X								D412-694-011	SPACEDOOR™ INSTALLATION
	X							D412-694-013	PANEL INSTALLATION (OPTIONAL)
4		X						D412-694-015	REPLACEMENT WINDOW KIT
			X					D412-694-017	BEARING OVERHAUL KIT
1				X				D412-694-01	DOOR ASSEMBLY
1					X			D412-694-02	DOOR ASSEMBLY
1						X		D412-694-03	DOOR ASSEMBLY
1							X	D412-694-04	DOOR ASSEMBLY
2								D2126-0730	SEAL
4								D3090-1	SHIM
4								D3090-3	SHIM
2								D3108-1	DECAL
2								D3108-2	DECAL
4								D3108-3	DECAL
4								D3108-5	DECAL
2								D3108-7	DECAL
						1	1	D3110-1	ESCUTCHEON
						1	1	D3110-3	HANDLE
				1	1			D3110-5	HANDLE ASSEMBLY
						1	1	D3111-041	PLATE ASSEMBLY
						2	2	D3112-1	GUIDE
						1	1	D3113-1	SPRING
						1	1	D3114-1	PIVOT
				1	1			D3115-1	BRACKET
2								D3116-1-0500	SEAL
						1	1	D3116-11-0180	SEAL
2								D3116-3-0500	SEAL
						1	1	D3116-5-0680	SEAL
				1	1			D3116-7-0680	SEAL
				1	1			D3116-9-0770	SEAL
		1						D3117-1-0980	SEAL RETAINER
		1						D3117-3-0980	SEAL FILLER
4								D3118-3	SIGN ASSEMBLY
4								D3118-5	SIGN ASSEMBLY
						1		D3119-041	COVER ASSEMBLY
							1	D3119-042	COVER ASSEMBLY
						1		D3120-1	COVER
							1	D3120-2	COVER
						1		D3120-3	COVER
							1	D3120-4	COVER
				3	3			D3121-041	BRACKET ASSEMBLY ("ROLLER")
				1				D3121-043	BRACKET ASSEMBLY ("ROLLER")
					1			D3121-044	BRACKET ASSEMBLY ("ROLLER")
			7					D3121-21	SCREW

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Revision: B

Date: 04.10.07

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
			5					D3121-241	BEARING ASSEMBLY
				1	1			D3122-1	LEVER
				2	2			D3123-1	CAM
				1	1			D3124-1	HOOK
				1	1			D3124-2	HOOK
						1	1	D3125-1	LEVER
						1	1	D3125-3	LEVER
						1	1	D3125-5	LEVER
						1	1	D3125-7	LEVER
				1	1			D3126-1	BRACKET ("SLIDER")
				1	1			D3126-3	BRACKET ("SLIDER")
				5	5			D3126-5	BRACKET ("SLIDER")
				1	1			D3127-1	SPACER
						1	1	D3128-1	SHIM
						2	2	D3129-1	LEVER
						2	2	D3130-1	CLEVIS BASE
						1	1	D3131-1	STOP
				1				D3132-041	ROD WELDMENT
					1			D3132-042	ROD WELDMENT
					1			D3133-041	ROD WELDMENT
				1				D3133-042	ROD WELDMENT
						1	1	D3134-1	ROD
						1	1	D3134-3	ROD
				1	1			D3135-041	HANDLE WELDMENT
		1						D3136-041	WINDOW ASSEMBLY
				2				D3137-041	BRACKET ASSEMBLY ("ROLLER")
			1					D3137-3	GUIDE
			1					D3137-5	WASHER
				1				D3138-1	COVER
					1			D3138-2	COVER
				1	1			D3139-1	GUARD
				1				D3139-3	GUARD
					1			D3139-4	GUARD
				1				D3140-05	DOOR
					1			D3140-06	DOOR
						1		D3140-07	DOOR
							1	D3140-08	DOOR
				2	2			D3141-1	SPRING
						1	1	D3143-1	CLEVIS
						3	3	D3143-3	CLEVIS
						1		D3144-1	DOUBLER
						1		D3144-105	DOUBLER
						1		D3144-107	DOUBLER
				1				D3144-109	DOUBLER
				1	1			D3144-111	DOUBLER
					1			D3144-115	DOUBLER
							1	D3144-117	DOUBLER
							1	D3144-119	DOUBLER

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Revision: B

Date: 04.10.07

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
							1	D3144-121	DOUBLER
					1			D3144-123	DOUBLER
				1	1			D3144-13	DOUBLER
				1				D3144-3	DOUBLER
						1		D3145-1	HINGE BRACKET
							1	D3145-2	HINGE BRACKET
						1		D3146-1	HINGE BRACKET
							1	D3146-2	HINGE BRACKET
						2	2	D3147-1	PIN
				2	2			D3148-1	CLEVIS
						2	2	D3149-1	STRIKER PLATE
						2	2	D3150-1	GUIDE
				1	1			D3151-041	DOUBLER ASSEMBLY
				1				D3152-041	BRACKET ASSEMBLY
					1			D3152-042	BRACKET ASSEMBLY
	1							D3153-11	PANEL
	1							D3153-12	PANEL
	1							D3153-13	PANEL
	1							D3153-14	PANEL
	1							D3153-15	PANEL
	1							D3153-16	PANEL
						1	1	D3154-1	KEY
				1	1			D3155-041	BRACKET ASSEMBLY
				1	1			D3155-042	BRACKET ASSEMBLY
				2	2			D3156-1	BRACKET
						2	2	D3157-1	SPACER
						3	3	D3159-041	BRACKET ASSEMBLY
						1		D3159-043	BRACKET ASSEMBLY
							1	D3159-044	BRACKET ASSEMBLY
				12	12			D3162-041	BRACKET ASSEMBLY
				1				D3163-041	COVER ASSEMBLY
					1			D3163-042	COVER ASSEMBLY
				1				D3183-041	BRACKET ASSEMBLY ("ROLLER")
					1			D3183-042	BRACKET ASSEMBLY ("ROLLER")
			2					D3183-045	BEARING ASSEMBLY
				1	1			D3203-1	HANDLE ASSEMBLY
2								D3300-1	WINDOW
				2	2			D3308-1	DOUBLER
				55	55	21	21	80-005-2-8	INSERT (OR SL2052-3-4)
	60							A6K75	RIVNUT
				10	10			AN525-10R6	SCREW
				8	8	4	4	AN525-10R7	SCREW
						8	8	AN960JD10	WASHER
				18	18	4	4	AN960JD10L	WASHER
				13	13	32	32	AN960JD10LL	WASHER
				6	6			AN960JD416L	WASHER
						4	4	AN960JD6L	WASHER
				6	6			AN960JD8	WASHER
						2	2	AN960JD8L	WASHER

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Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
						2	2	AN960JD8LL	WASHER
						10	10	ASL4-632-80	INSERT
				87	87	47	47	BSP45	RIVET
						14	14	FW10-032	WASHER
						6	6	FW4-032	WASHER
				12	12			M7885/2-4	RIVET (OR CR3213-4-3)
						3	3	M7885/3-4	RIVET (OR CR3212-4-3)
						2	2	MS20392-1C11	PIN
						5	5	MS20392-2C15	PIN
				2	2			MS20392-2C17	PIN
				2	2	2	2	MS20392-2C9	PIN
				2	2			MS20392-3C21	PIN
				8	8			MS20426AD3	RIVET
				20	20			MS20426AD4	RIVET
				A/R	A/R			MS20995-C20	LOCKWIRE
						6	6	MS21042L06	NUT
				6	6	2	2	MS21042L08	NUT
						5	5	MS21042L3	NUT
				4	4			MS21042L4	NUT
				4	4			MS21072-L3	NUTPLATE
				6	6	9	9	MS24665-151	COTTER PIN
				4	4			MS24693-S271	SCREW
						2	2	MS24694-C4	SCREW
				4	4			MS24694-C5	SCREW
			1					MS24694-S101	SCREW
				6	6			MS24694-S5	SCREW
				18	18			MS24694-S50	SCREW
						4	4	MS24694-S56	SCREW
						2	2	MS24694-S6	SCREW
						4	4	MS24694-S60	SCREW
				4	4			MS24694-S98	SCREW
						2	2	MS25281-R6	CLAMP
				2	2	2	2	MS27039-1-05	SCREW
				14	14	12	12	MS27039-1-06	SCREW
				13	13	6	6	MS27039-1-08	SCREW
						2	2	MS35206-231	SCREW
				2	2			MS35275-233	SCREW
				2	2			MS35649-264	NUT
						4	4	MS35650-305T	NUT
				2	2			MS35650-3252	NUT
				2	2	3	3	MS51859-7	WASHER
						4	4	NAS1169-10L	WASHER
						1	1	NAS388-6-12P	SCREW
	60					14	14	NAS388-6-8P	SCREW
	60					15	15	NAS391B6P	WASHER
				7	7			NAS43DD3-10	SPACER
				6	6			NAS43DD3-14	SPACER
						2	2	NAS43DD3-40	SPACER

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Date: 04.10.07



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9316	REV. A SHEET 1 OF 1
DATE 05.12.12		TITLE PART SUBSTITUTION	SCALE NTS
A	05.12.12	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D412-694 REV. B

REF. CANADIAN STC: SH05-10

REF. FAA STC: SR02086NY

ON D412-694-011 AT CHG 005 OR LATER

D3137-045 BRACKET ASSEMBLY

REPLACES

D3137-041 BRACKET ASSEMBLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

DATE: 05.12.12
CERT. NO.: SH05-10
ISSUE NO.: 1

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